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D2521**Job Sheet 190896****Part No:** D2521**Job Qty:** 10 pcs**Part Name:** Individual Bearpaw**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 2/19/19**Job Tracking No:****Due Date:** 4/15/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DWG REV J IPP Rev:A 08-10-01 New Manufacturing Method JLM Verified By:EC**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Waterjet - Omax - 1	10 pcs	4/15/19	4/15/19	0.00	3.77	Waterjet - Omax	DAS 52 9-89	19/03/15
130	HAAS 4 Axis - B4B	10 pcs	4/15/19	4/15/19	0.39	17.36	HAAS - 1 - B4B		19/03/18
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
140	QC 2	10 pcs	4/15/19	4/15/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51	DAS 52 9-89	19/03/18
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		

Plex 2/19/19 2:36 PM Dart.lajeunesse.marie

				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
150	QC 8	10 pcs	4/15/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
160	Packaging 3-1 - Stock - B4B	10 pcs	4/15/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B

MAR 22 2019

				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	10 pcs	4/15/19	0.00 0.00	QC 21 - SA - 21	DAG 21 MAR 25 2019
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 120 - Waterjet 2 OMAX (Waterjet 2) Cut Blank as per D2521 blank file Descriptions: 130 - (HAAS CNC vertical machine #1) 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2521 Identify as D2521 140 - (QC2- Inspect parts off machine FAI/FAIB) 150 - (QC8- Inspect parts - second check) 160 - (Identify as per dwg & Stock Location: _____) 170 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	70 sf (7 ea)	120-Waterjet - Omax - 1	S143330	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
120-Waterjet - Omax - 1	MUHMWB10	70	846	0	
Part Specifications					
Specifications could not be found.					

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DART AEROSPACE LTD		Work Order:	190 896
Description: Bearpaw		Part Number:	D2521
Inspection Dwg: D2521 Rev: J		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article** ☐ **Prototype**

Inspection Sheet Drawing Dimension			Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dim	Min	Max					
A	0.260	0.266	0.260	✓		G.P.	
B	0.90	0.96	0.932	✓		Ver	
C	0.27	0.330	0.310	✓		D.G.	
D	0.470	0.530	0.500	✓		Ver	
E	21.740	21.760	21.750	✓		TAPE	
F	0.72	0.780	0.750	✓		Ver	
G	0.35	0.410	0.38	✓		Ver	
H	11.490	11.570	11.500	✓		TAPE	
I	3.41	3.47	3.44	✓		Ver	
J	11.790	11.810	11.800	✓		TAPE	
K	9.47	9.53	9.500	✓		TAPE	
L	7.190	7.210	7.200	✓		Ver	
M	6.910	6.970	6.94	✓		Ver	
N	44.47	44.530	44.5	✓		TAPE	
O	6.590	6.650	6.62	✓		Ver	
P	0.940	0.980	0.970	✓		Ver	
Q	18.97	19.03	19.00	✓		TAPE	
R	0.350	0.410	0.380	✓		Ver	
S	0.740	0.780	0.760	✓		Ver	
T	0.240	0.280	0.260	✓		Ver	
U	0.370	0.410	0.390	✓		Ver	
V	0.740	0.780	0.760	✓		Ver	
W	0.740	0.780	0.770	✓		Ver	

Measured by: DAS 52
Date: 19/03/18

Audited by: [Signature]
Date: 19/03/22

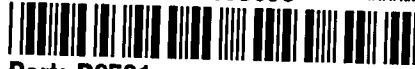
Prototype Approval: N/A
Date: N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D205-564-011 & D430-688-011	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	
C	06.08.31	Dimensions updated per D2521 Rev. J	KJ/JLM [Signature]	[Signature]



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Container No: S163050



Part: D2521

Job No: 190896

Serial No/Batch: S163050

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/15/19